Friday, 06/07/2007 9:49:01 AM

User:

Linda Lacelle

### **Process Sheet**

Customer

Job Number

: CU-DAR001 Dart Helicopters Services : 33239

**Estimate Number** 

: 11877

P.O. Number This Issue

Prsht Rev.

First Issue

: NA

: 06/07/2007

: NC

: 27/06/2007

S.O. No. : NIA

Type

**Previous Run** Written By

Checked & Approved By

Comment

: MACHINED PARTS

Material

**Due Date** 

**Drawing Name** 

**Part Number** 

**Drawing Number** 

: D2208

: END CAP

: D2208 REV B

: N/A **Project Number Drawing Revision** 

: NA : 04/07/2007

Qty:

20 Um: Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6061-T6 .063 Sheet

M6061T6S063 1.0



Comment: Qty.:

0.1531 sf(s)/Unit

Total: 6061-T6 .063 Sheet

5052-H32 or 6061-T6 - .063" Thick

Batch M 193

3.0618 sf(s)

2.0 SHEAR

3.0

Comment: |

AAS CNC VERTICAL MACHINING #1

as per folie FA 032

4.0



B 07-07-04



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK



Dáte:

Friday, 06/07/2007 9:49:01 AM

User:

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 33239

Part Number: D2208

Job Number:



Seq. #:

**Machine Or Operation:** 

**Description:** 

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



7.0

QC21

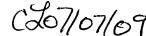




Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





Form: rorocess

Wednesday, 6/27/2007 3:25:59 PM

Kim Johnston

Page 1

#### **Process Sheet**

: END CAP **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 33239 **Estimate Number** : 11877 Part Number P.O. Number : D2208 REV &C PREUM S.O. No. : **Drawing Number** This Issue : 6/27/2007 : NC Prsht Rev. Project Number First Issue : // Type : MACHINED PARTS **Drawing Revision** Material Previous Run : 7/4/2007 Each **Due Date** Um: Written By Checked & Approved By : Est A 01.03.08 Comment New Issue POSITIVE RECALL **Additional Product** Job Number: Machine Or Operation: Description: Seq. #: 1.0 6061-T6 .063 Sheet Changed. prog-1 fai ready to RUN. Comment: Qty.: 0.1531 sf(s)/Unit Total: 6061-T6 .063 Sheet 5052-H32 or 6061-T6 - .063" Thick Batch M 100 285 2.0 SHEAR Comment: SHEAR Shear blanks: 5.100" x 4.100" 3.0 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA 032 Deburr 4.0 QC2 67-06-18 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 5.0 QC8 SECOND CHECK Comment: SECOND CHECK PACKAGING 1 PACKAGING RESOURCE #1 6.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES							
DATE STEP		PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
			QA: N/C Closed:	Date:

NCR:		W	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC		Corrective Action Section B	Verification Approval	Approval				
DATE	SIEF	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date,	Section C	Chief Eng	QC Inspector		
क्रीक्षीउँ	\$ 20 water set	one part DUTAP. WHER Set cut inside the part leaving a small grove in the part RX. past more	Posion			Er	Posiour	er offorfor		

NOTE: Date & initial all entries

Date: User: . Wednesday, 6/27/2007 3:25:59 PM

Kim Johnston

**Process Sheet** 

· Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 33239

Part Number: D2208

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



**POSITIVE RECALL** 

**EFFECTIVE** RELEASED

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	o:	PAR #: Fault Category: NCR	R: Yes	No DQA	\:	Date:					

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Approval	Annroyal	
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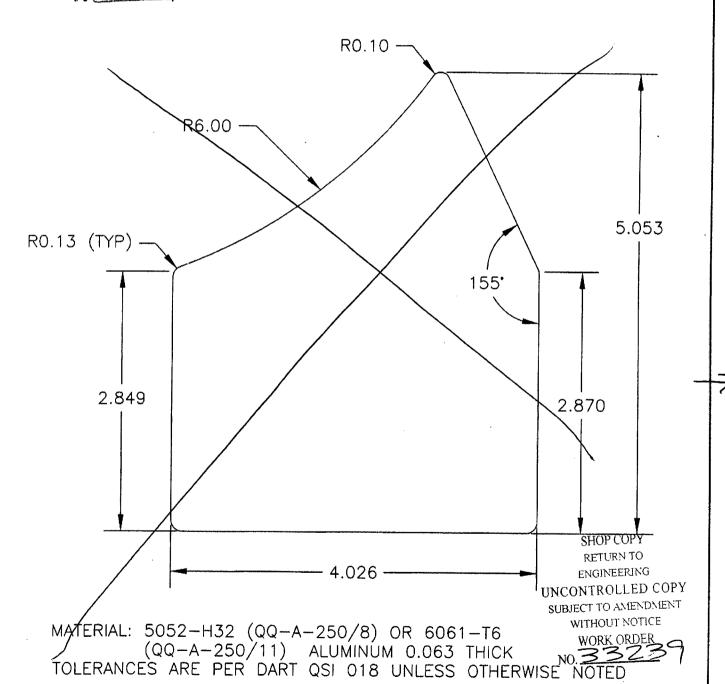
NOTE: Date & initial all entries

Drawing   Dimension   Accept   Reject   Method of   Inspection   Comments	DART AEROS	PACE LTD				Work Or	der: 2	3239	
FIRST ARTICLE INSPECTION CHECKLIST	Description: En	d Cap				Part Num	ber:	D2208	
FIRST ARTICLE INSPECTION CHECKLIST	Inspection Dwa	: D2208 Rev	: & C _				F	Page 1 of 1	-
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CHEC	KED	APPROVED	DRAWING NO.	REV. B
	#	1 4	D2208 SHEET	1 OF 1
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Α		94.09.01	NEW ISSUE	
В		01.02.22	REDRAWN	

RELEASED



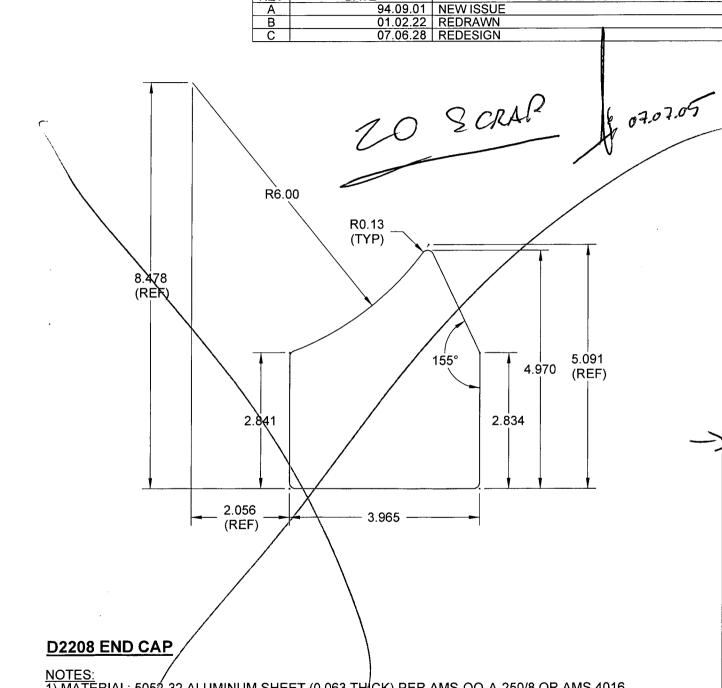
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DESIGN DRAWN BY DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA CHECKED APPROVED DRAWING NO. REV. C D2208 SHEET 1 OF 1 DATE TITLE SCALE 07.06.28 **END CAP** 1:2 DATE DESCRIPTION

-2



1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 TH/CK) PER AMS-QQ-A-250/8 OR AMS 4016 (RÉF. DART SPEC. M5052H32S.063) OR

6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027

(REF. DART SPEC. M6061T6S.063)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REV

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

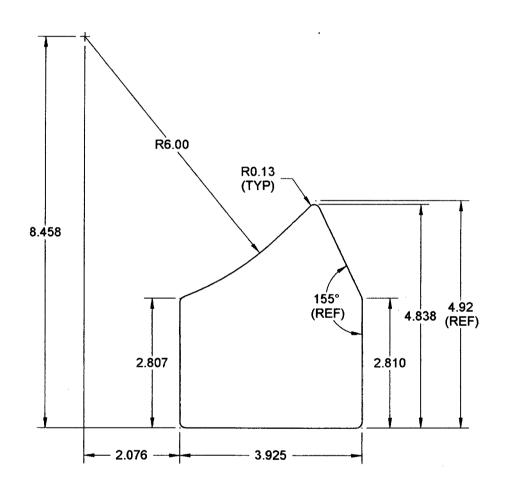
5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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## PRELIMINARY ISSUE

DESIGN DRAWN BY DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED APPROVED		DRAWING NO. D2208	REV. C SHEET 1 OF 1	
07.07.05		END CAP	SCALE 1:2	
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REV	DATE	DESCRIPTION	Π
Α	94.09.01	NEW ISSUE	
В	01.02.22	REDRAWN	
C	07 07 05	REDESIGN	



#### **D2208 END CAP**

NOTES:
1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.063) OR 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/11

(REF. DART SPEC. M6061T6S.063)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

#### **COPYRIGHT © 1994 BY DART AEROSPACE LTD**

'DAR' AEROSPAÇE LTD	33239	
		*-
Description: END LAD	Part Number:	D 2768
Inspection Dwg: D 3368 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

	х	First Artic	le	Proto	type	•
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3,925	± 6.010	3.9245	¥	·	UERN	-
4.838	± 2010	4.838	**		UERN	
R 1500	± 0.030	:155	*		R.6	
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Date:	07-07-09	Date:	57/07/09	Date:	

Rev	Date	Change		- Andrews - Andr	Revised by	Approved
А	0441-11	New Issue	7/0	D 206539013	KJ/JLM	

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# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
oHoHo	#20 160	1 A	S	othelos						
A	2310	Chang from HAAS to NATO jet and ADD dubur ste								
					<u> </u>					

Part No:	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C Closed:		Date:

NCR:			WORK ORD	ER NON-CONFORMANO	CE (NCR)			-					
DATE		Description of NC		Vorification	A								
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	- Verification Section C	Approval Chief Eng	Approval QC Inspector					
				2.									
								· ·					

NOTE: Date & initial all entries